

Date: Monday, 11/21/2005 7:40:54 PM  
 User: Linda Lacelle

## Process Sheet

Split - 2 Job 0103

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT WEB
Job Number	: 24862	Part Number	: D3282041
Estimate Number	: 10791	Drawing Number	: D3282 REV C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/21/2005 S.O. No. : N/A	Drawing Revision	: C
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 12/20/2005 Qty: 10 Um: Each
Previous Run	: N/A		
Written By	: See comment below		
Checked & Approved By	: See comment below		
Comment	: Est Rev:B 05.09.23 Procedure change KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2792130	EXTRUSION
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)		
Pick: Qty Part Number Description Batch 1 D2792-130 Extrusion B24030 Pm 05-11-28		
Identify as D3282-1		
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1		
Cut to length as per Dwg D3282.		
Pm 05-11-28		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1		
1-Machine as per Folio FA579 & Dwg D3282		
2-Deburr		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
Pm 05/12/03 : 11		

PTO

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

ML 05/12/12 11

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AM 05-12-13



7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 05-12-16



8.0 D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler B25339

DP 05-12-16

3 2

9.0 MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total: 570.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet M11721

DP 05-12-16  
PM 05-12-20

2 3

10.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web

A/RN/ALPS-3 417395

DP 05-12-16 03



11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J-06-01-03 03

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Linda Lacelle

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

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Job Number:



Seq. #:	Machine Or Operation:	Description :
12.0	PACKAGING 1	PACKAGING RESOURCE #1
		DPo6-1-3 ③
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: LG	
13.0	DC	DOCUMENT CONTROL
		DPo6/01/05 ③
	Comment: DOCUMENT CONTROL Inspection Level 21	

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/01/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Dart Aerospace Ltd.  
Hawkesbury

## Job Costing Report

Nov 17, 2005  
03:30 pm

Work Order No : 0024862 -2  
 Project Name : D3282-041  
 Project For : WK550  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3282-041  
 Description : Float Web  
 Manufactured : Yes  
 Amount Req'd : 8.0  
 Amount Done : 0  
 Start Date : 11-17-05  
 Est Finish Date : 12-20-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Margin : 0.000%  
 Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00	0.00	0.00
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

Labour Hrs/Amount Done :	Estimated	Actual
Profits/(Loss) :	0.00	0.00
	0.00	0.00